

Date: Tuesday, 4/17/2007, 11:09:33 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD TUBE ASSEMBLY
Job Number	: 31851		
Estimate Number	: 10467		
P.O. Number	: <i>N/A</i>	Part Number	: D3391021
This Issue	: 4/17/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D3391 REV.F
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 31850	Drawing Revision	: F
	Type : MACHINED PARTS	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 5/20/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	1 Um: Each
Comment	Est. A 05.09.13 New issue KJ/JLM Est. B 06.02.10 Dwg rev.D ecn 773 EC Est. C 06.05.02 Added inspections EC est D 07.03.13 rev F dwg EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6013047	SKIDTUBE MAT'L
-----	----------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 SKIDTUBE MAT'L

Pick:

Qty	Part Number	Description	Batch
1	D6013-047	Extrusion	<i>BE 07-04-19</i>

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1
 Cut extrusion to 46.52 +0.010 -0.020

BE 07-04-19

3.0	BENDING	BENDING MACHINE
-----	---------	-----------------



Comment: Nc bender
 Bend as per Dwg D3391 Using Bend Prog 3391021

EL 7-5-7

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

DP 7-5-8

5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
 1-Machine as per Folio FA590 Rev. *AA* & Dwg D3391 Rev. *E*
 Identify as D3391-1

2-Deburr

J.F. 07/05/15 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 11:09:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31851

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/05/15

①

7.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Drill X1 Aft cap as per Dwg D3391

BL 07-05-22

①

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BL 07-05-22

①

9.0

QC8

SECOND CHECK



Comment: SECOND CHECK

nmh 07/05/22

①

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill and c/sink float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)
(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5-Deburr

7-5-23

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

For 05-25

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

JD 7-6-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 11:09:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31851

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



IX
07/08/16

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-l

14.0

POWDER COATING

POWDER COATING



①

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR/m-l

07-08-16

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL

07/08/17 ①

16.0

NAS1330C3KB166

INSERT



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Rivnut

Pick:

Qty

Part Number

Description

Batch

14

NAS1330C3KB166

Insert

m/03279.

FL.

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg

FL

07/08/17 ①

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/17

19.0

D3401041

Tow Cap Assembly



IX

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tow Cap Assembly

Pick:

Qty

Part Number

Description

Batch

1

D3401-041

Tow Cap

B31346

07/08/18

u/m-l

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 11:09:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31851

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D356413

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

1333800

MS/M-L

21.0

D356613

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

1332744

MS/M-L

22.0

AN3C4A

BOLT



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

4

AN3C4A

Bolt

M105057

MS/M-L

23.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

4

NAS1515H3L

Washer

M104603

MS/M-L

24.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

washer

M105143

MS/M-L

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install tow Cap as per Dwg D3391

Identify as D3391-021

MS 0708-17 (1)

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect thread of each insert using DT8821

Er 09/08/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: R Date: 07/08/22

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 11:09:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 31851

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

31845

28.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

220408/22

Job Completion



u 07-08-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

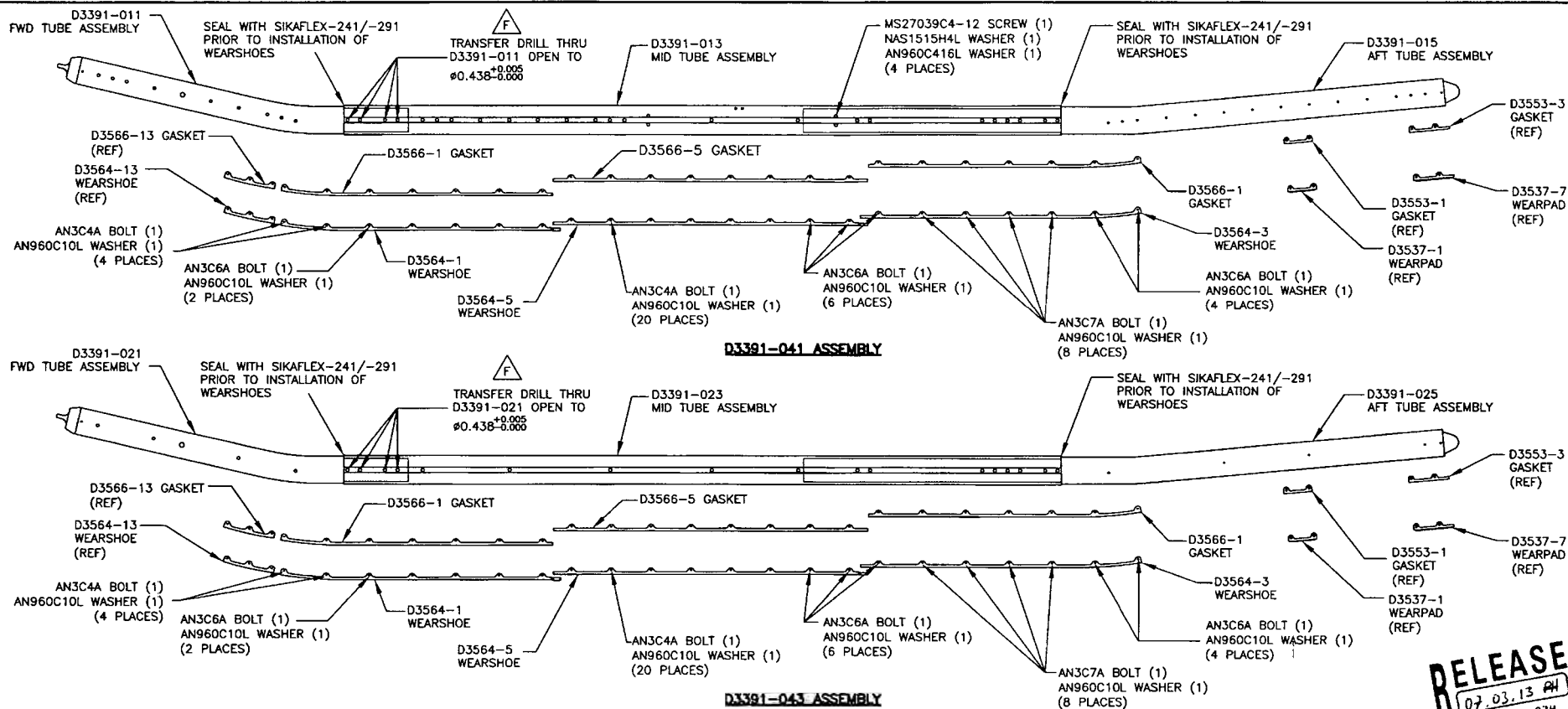
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

12



D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
1	1	D3391-021	FWD TUBE ASSEMBLY
1	1	D3391-023	MID TUBE ASSEMBLY
1	1	D3391-025	AFT TUBE ASSEMBLY
1	1	D3564-1	WEARSHOE
1	1	D3564-3	WEARSHOE
1	1	D3564-5	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	AN960C10L	WASHER
4	4	MS27039C4-12	SCREW
4	4	NAS1515H4L	WASHER
4	4	AN960C416L	WASHER

GENERAL NOTES

- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCOYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (#0.250-#0.257) FOR WEARSHOE INSERTS. C/SINK #0.391/#0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
31851

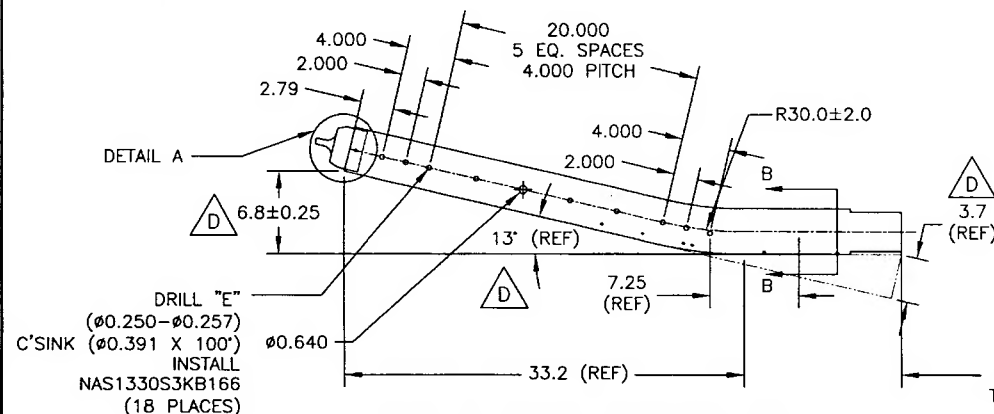
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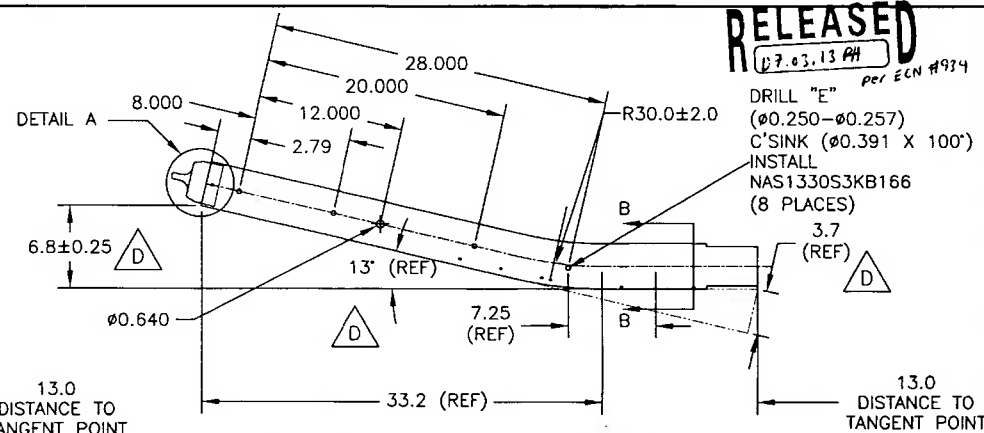
F	07.01.18	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021
E	06.04.25	CHANGE TOLERANCE, EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. FORT WADSWORTH, TX
CHECKED	APPROVED	DRAWING NO. D3391
DATE		TITLE 412 FLOAT SKIDTUBE
07.01.18		SCALE NTS

RELEASED
07.03.13 AH
per Ecn #934

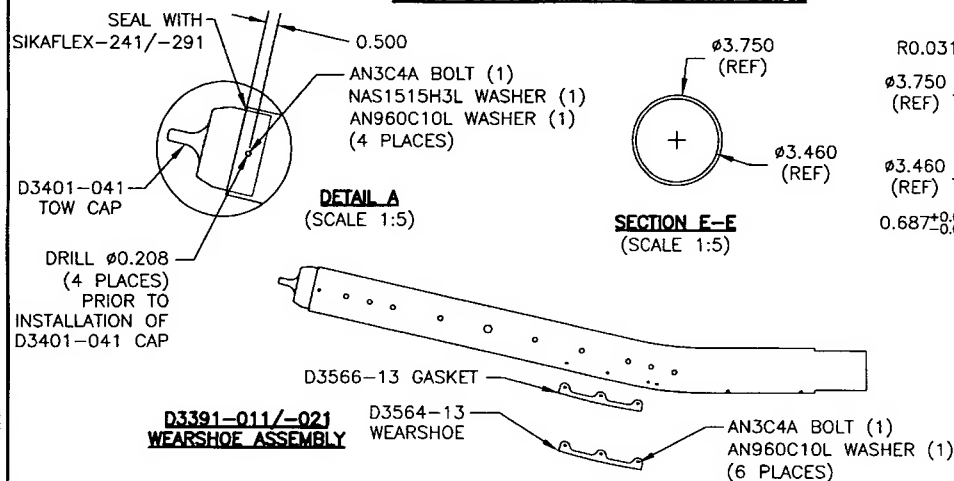
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 07.03.13 AH
 per ECN #934



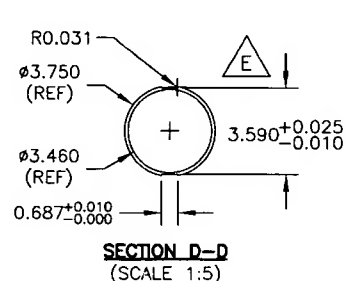
D3391-011 ASSEMBLY AND BENDING DETAIL



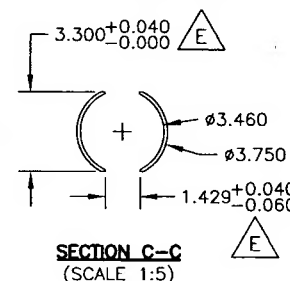
D3391-021 ASSEMBLY AND BENDING DETAIL



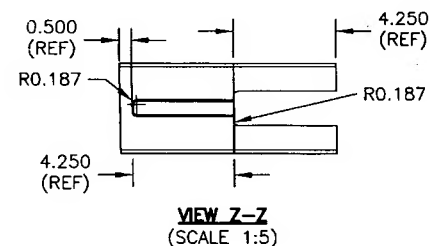
D3391-011/-021 WEARSHOE ASSEMBLY



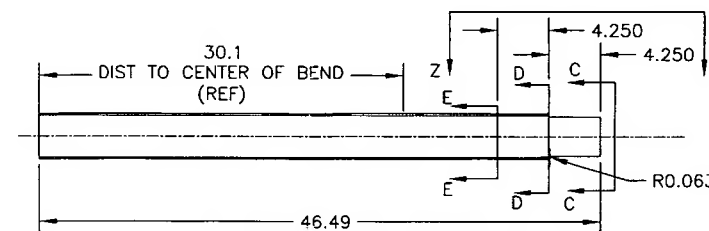
SECTION D-D (SCALE 1:5)



SECTION C-C (SCALE 1:5)



VIEW Z-Z (SCALE 1:5)



D3391-1 DRILLING AND CUTTING DETAIL (MAKE FROM D6013-047 SKIDTUBE MATERIAL)

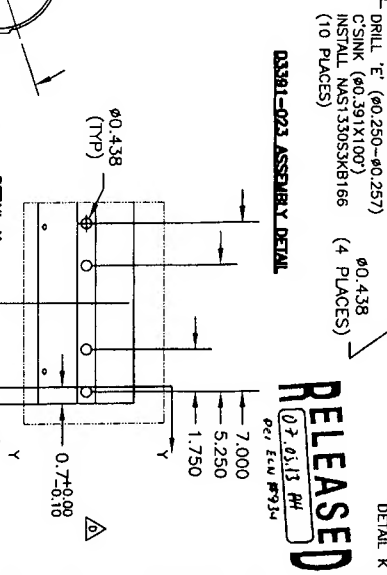
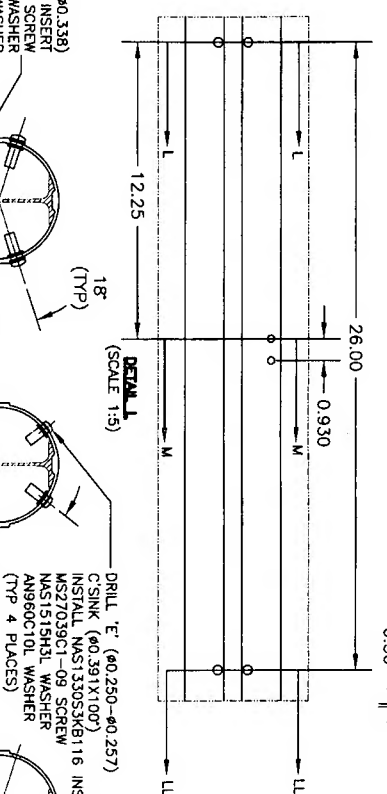
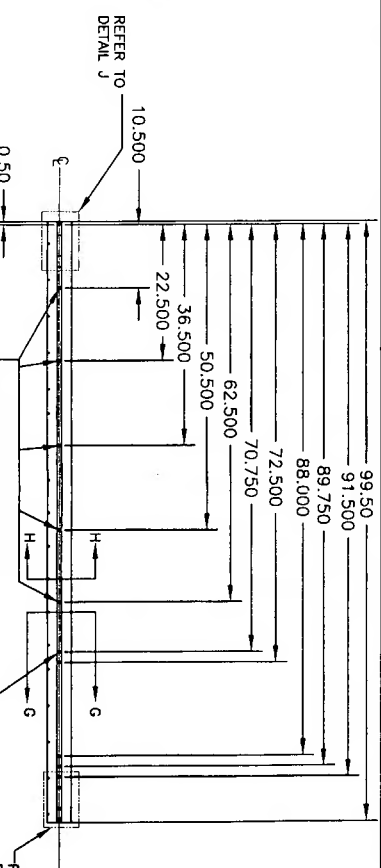
D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
10	10	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER
30	20	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)

5
 DRILL "E"
 (0.250-0.257)
 C'SINK (0.391 X 100")
 INSTALL
 NAS1330S3KB166
 (12 PLACES)

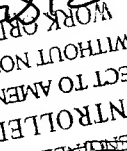
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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 31865-1

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DATE 07.01.18		TITLE 412 FLOAT SKIDTUBE		REV. F SHEET 2 OF 5 SCALE 1:10

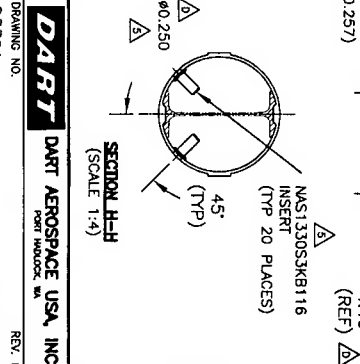
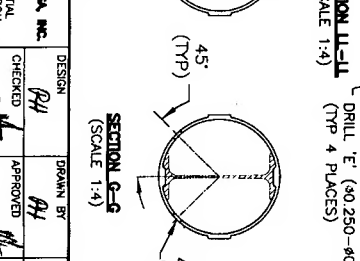
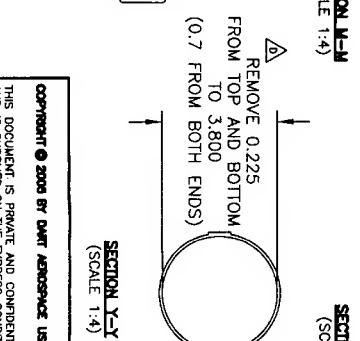


SECTION 1-1
(SCALE 1:4)

NO. 3185
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
FROM TOP AND BOTTOM
REMOVE 0.030
TO 3.610



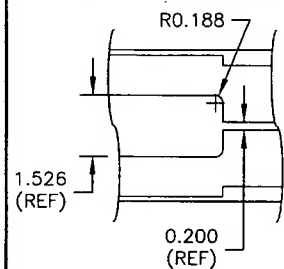
SECTION 1-1
(SCALE 1:4)



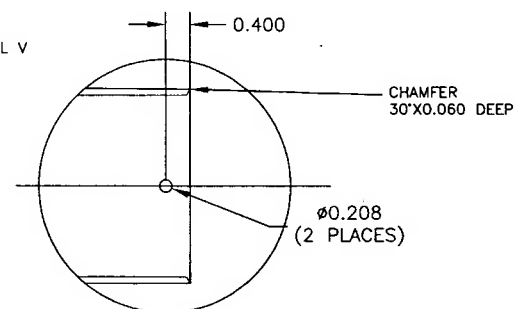
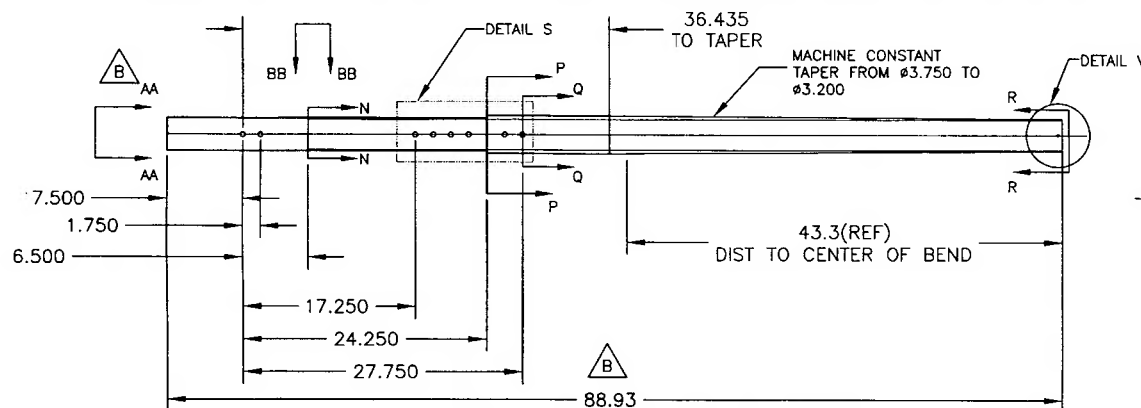
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CHECKED #1		APPROVED #1		DRAWING NO. D3331	
DATE 07.01.18				SHEET 3 OF SCALE 1:20	
				412 FLOAT SKIDTUBE	

 DAPT DART AEROSPACE USA, INC. FORT MONROE, VA		DESIGN BY <i>PH</i>	DRAWN BY <i>PH</i>
CHECKED <i>PH</i>	APPROVED <i>PH</i>	REVISIONS: 1. 07.01.18	
DRAWING NO. 03391		SHEET 3 OF 3	
TITLE 412 FLOAT SKIDTUBE		SCALE 1:2	

1:2

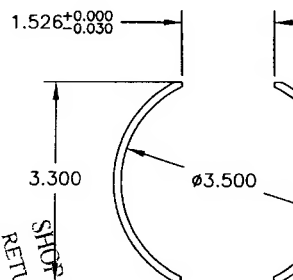


VIEW BB-BB
(SCALE 1:3)

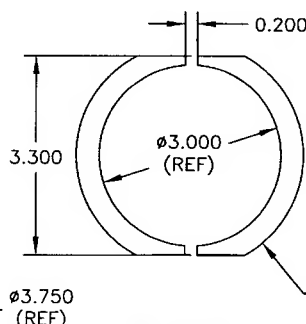


DETAIL V
(SCALE 1:2)

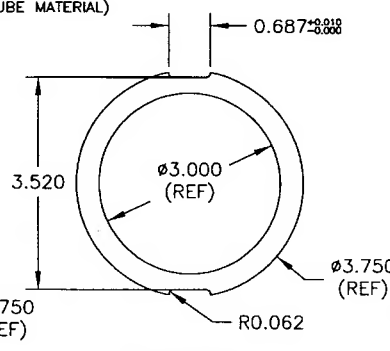
D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



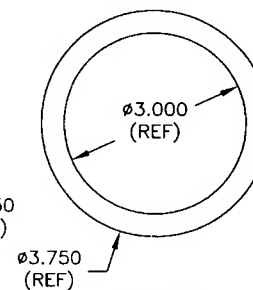
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(SCALE 1:2)



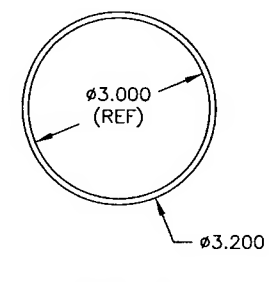
SECTION N-N
(SCALE 1:2)



SECTION P-P
(SCALE 1:2)

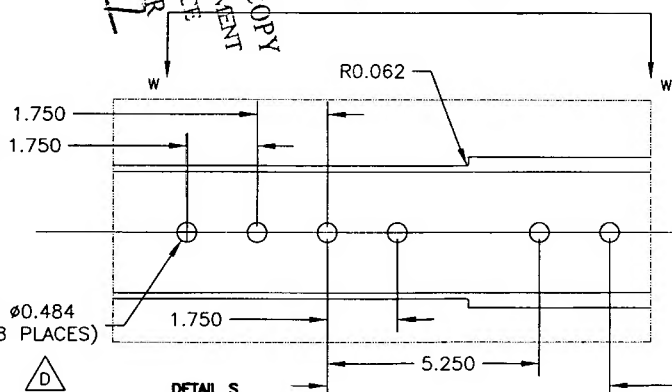


SECTION Q-Q
(SCALE 1:2)

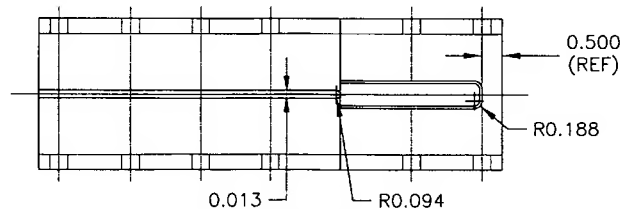


SECTION R-R
(SCALE 1:2)

NO. 31851
WORK ORDER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
RETURN TO
ENGINEERING
SHORT COPY



DETAIL S
(SCALE 1:3)



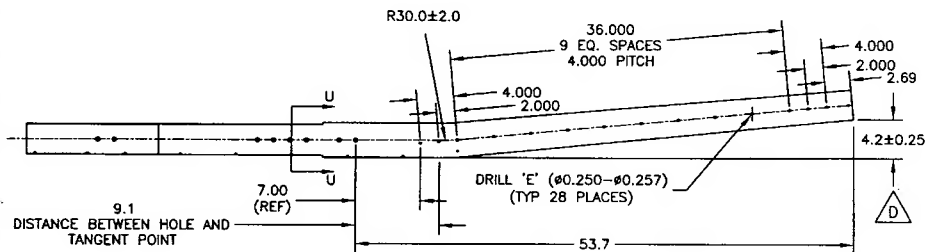
VIEW W-W
(SCALE 1:3)

RELEASED
07.05.13 PH
per ELN #934

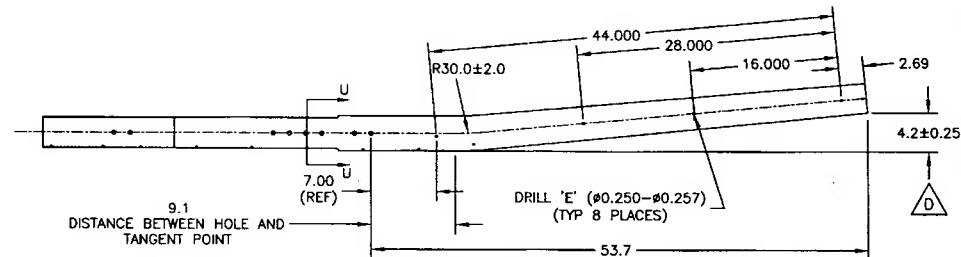
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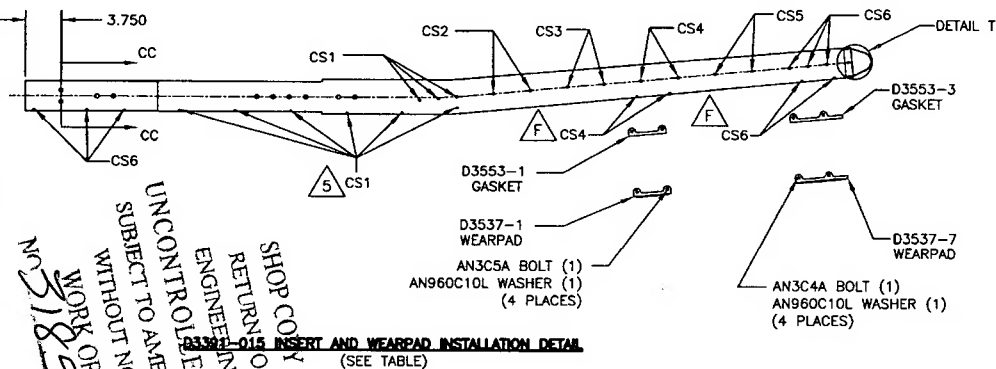
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA	REV. F
CHECKED PH	APPROVED PH	DRAWING NO. D3391	SHEET 4 OF 5
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	SCALE 1:12	



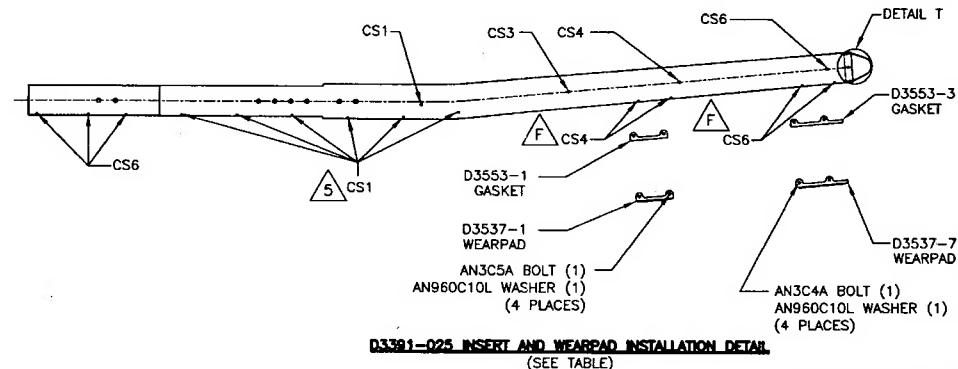
D3391-015 BENDING AND ASSEMBLY DETAIL



D3391-025 BENDING AND ASSEMBLY DETAIL



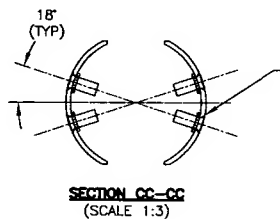
D3391-015 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)



D3391-025 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)

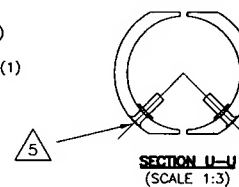
D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
18	14	NAS1330S3KB366	INSERT (OR AES10KB366)
4	2	NAS1330S3KB316	INSERT (OR NAS1330C3KB316)
8	6	NAS1330S3KB266	INSERT (OR NAS1330C3KB266)
4	2	NAS1330S3KB216	INSERT (OR NAS1330C3KB216)
16	12	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4	2	NAS1330S4KB151	INSERT (OR NAS1330C4KB151)
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
2	2	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER



SECTION CC-CC
(SCALE 1:3)

DRILL 'Q' (#0.332-#0.338)
C'SINK (#0.529X100")
NAS1330S4KB151 INSERT (1)
(4 PLACES)



SECTION U-U
(SCALE 1:3)

AN3C4A BOLT (1)
NAS1515H3L WASHER (1)
AN960C10L WASHER (1)
(2 PLACES)
DETAIL T
(SCALE 1:3)
SEAL WITH
SIKAFLEX-241/-291

C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	NAS1330S3KB366
CS2	4	2	Ø0.391	NAS1330S3KB366
CS3	4	2	Ø0.391	NAS1330S3KB316
CS4	8	6	Ø0.391	NAS1330S3KB266
CS5	4	2	Ø0.391	NAS1330S3KB216
CS6	16	12	Ø0.391	NAS1330S3KB166

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DESIGN PH	DRAWN BY BH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED H	APPROVED H	DRAWING NO. D3391
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	REV. F SHEET 5 OF 5 SCALE 1:12

RELEASED
07.03.13 RH
per ECN #934